

Date: Monday, 3/26/2007 3:27:05 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT BRACKET
Job Number : 31503	
Estimate Number : 10260	
P.O. Number : N/A	Part Number : D23623
This Issue : 3/26/2007 S.O. No. : N/A	Drawing Number : D2362 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : E1
Previous Run : 30877	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 4/30/2007 Qty: 10 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est: G 00.05.18 Added inspection level 8 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2265	Step Support Casting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Step Support

Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	B29807

Batch

B29807

mk 07/03/27

10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine per folio D2362-3

mk 07/03/28

16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

mk 07/03/28

10

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

BG 07-03-28

10

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SDD 07/04/01

10

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

touch ups. FK 07/04/03

10

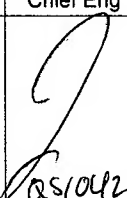



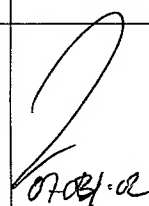
m103706

FK 07/04/02

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 27/04/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/02	6.0	Paint missing inside of bracket.	 05/04/02	Re-powder coating ensure part full coverage.	 07/04/03	 07/04/03	 05/04/02	 07/04/02

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:27:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 31503

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MF

07-04-04

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

B30971-

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

B30912-

MF 07-04-04

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement

as per Dwg D2362

Batch ~~M19738~~

M102565

MF 07-04-04

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

07/04/04

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

store

07/04/04

(10)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/04

Job Completion



07.04.10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



RELEASED
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	<i>CP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	<i>CP</i>	D2362
DATE		TITLE
98.12.04		STEP SUPPORT BRACKET
		SCALE
		1:2
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
D23 BEFORE MANUFACTURE
OK 01/03/04

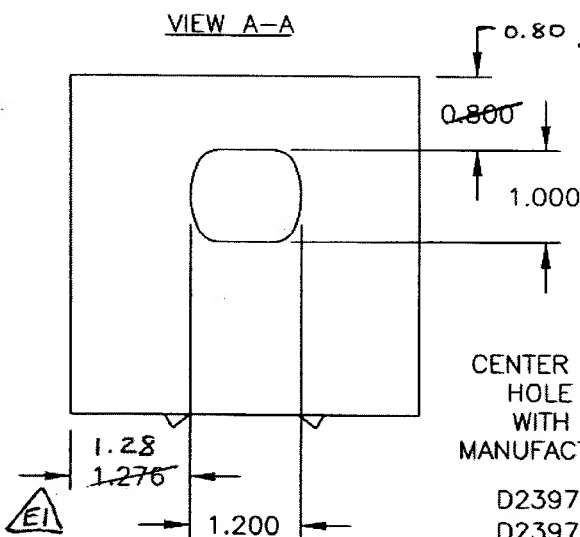
0.257 X 0.75 SLOT
REMOVE TIPS
FROM CASTING
MAX 0.080

CENTER D2397-1/-3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATION

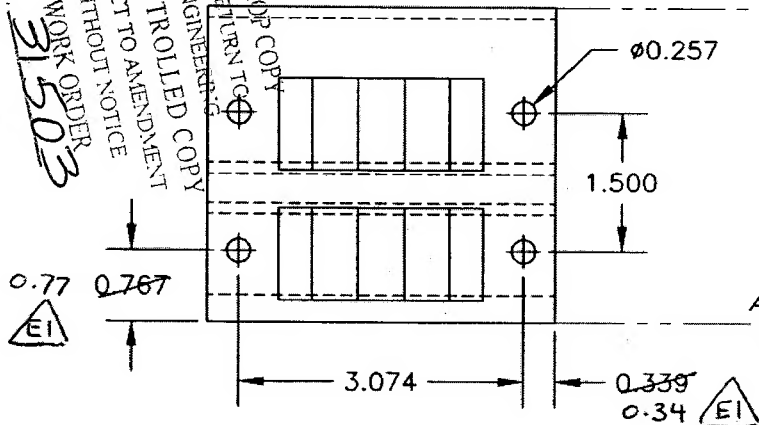
D2397-1 RUBBER CUSHION (1)
D2397-3 RUBBER CUSHION (1)

D2362-3

VIEW A-A



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31503



NOTES:

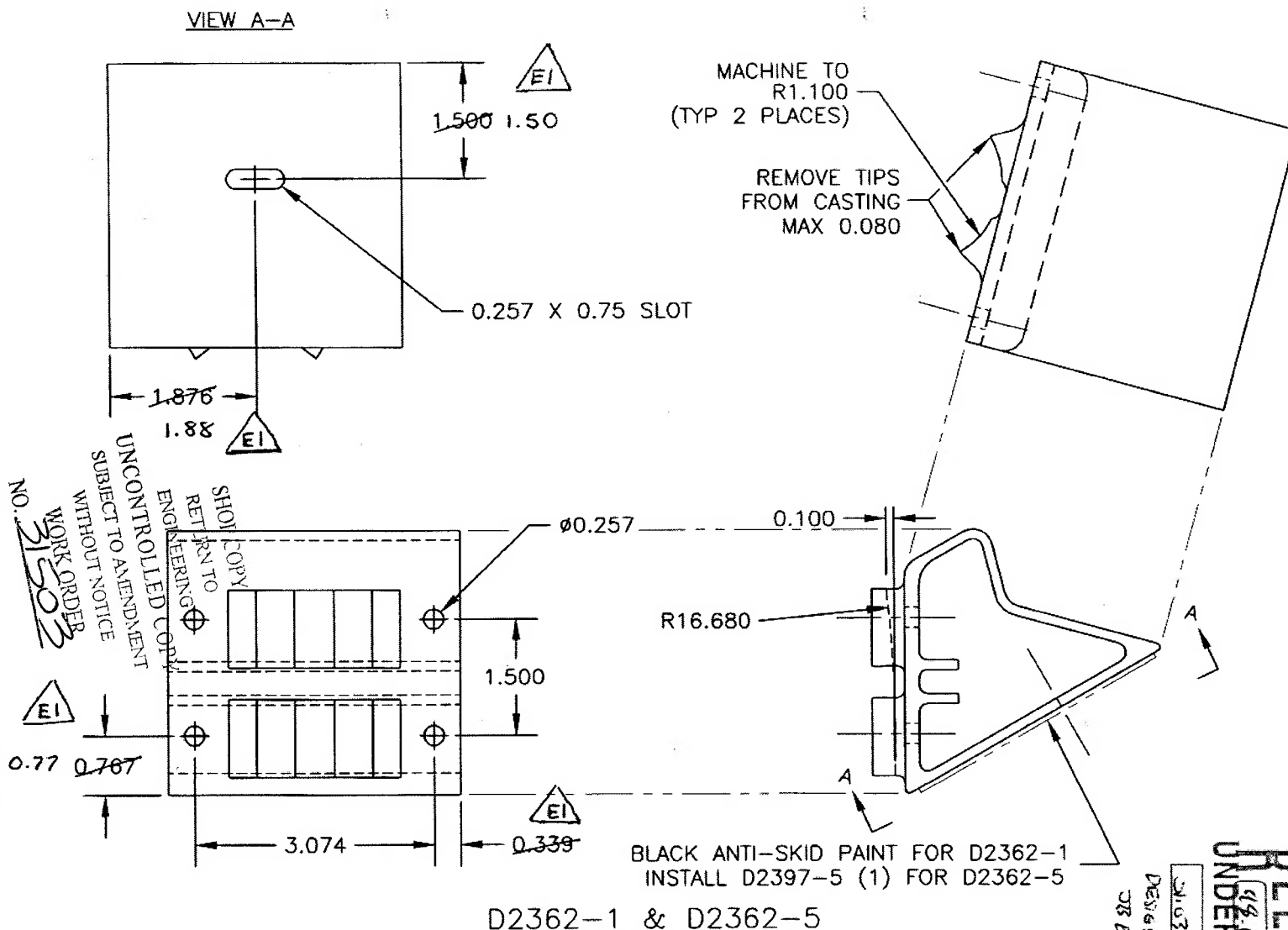
MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED CP	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	REV. E SHEET 2 OF 3
		SCALE 1:2



NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

REMOVE TIPS
FROM CASTING
MAX 0.080

BLACK ANTI-SKID PAINT

D2244-3.75

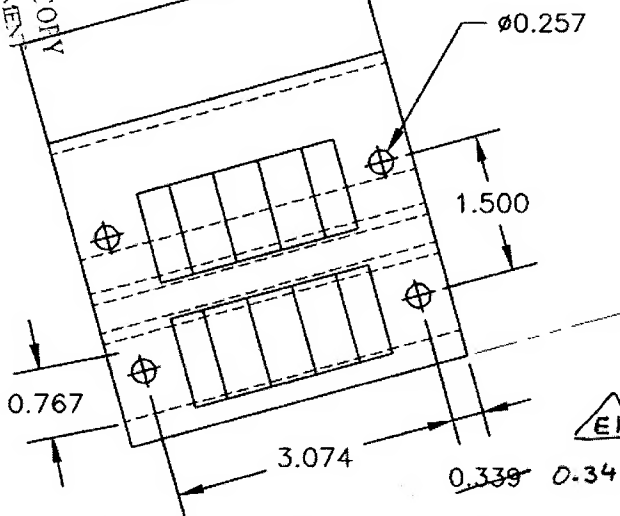
WELD PER DART 1/8
QSI 004

01.03.15 CP
DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE

OK 01/11/04

D2362-7

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31503



3.750 (REF)

UNDER REVIEW

RELEASED
98.12.14 KB



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
CHECKED	KE	APPROVED	KE	DRAWING NO. D2362	SHEET 3 OF 3
DATE	98.12.04	TITLE	STEP SUPPORT BRACKET	SCALE	1:2